

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014966**Date Inspected:** 27-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD**Segment # 10CE (Green Tag)**

This QA inspector performed visual testing and dimensional check on cope hole and welds access for OBG lift 10 East along with QA inspector (Manikandan) for smoothness. ABF inspection report no: CWAHIR-10CE-01 dated 26th May 2010. All these details noted and forwarded to team leader for further action.

Segment # 10CE (Green Tag)

Flatness measurement for Floor Beam at PP 92, PP 93 and PP 94 Cross Beam and Counter Weight Side.

Flatness measurement for Deck Panel to Corner Assembly from PP 92 to PP 93 and 94 Cross Beam and Counter Weight side.

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Flatness measurement for Side Panel to Corner Assembly from PP 92 to PP 93 and 94 Cross Beam and Counter Weight side and

Flatness measurement for Deck Panel to Deck Panel Diaphragm at PP 92 to PP 93 and PP 94 East and West side of the Diaphragm.

Segment # 9AW

This QA inspector observed ZPMC qualified welding personnel identified as 045227 perform Flux Core Arc Welding (FCAW), weld joint identified as SEG049A-014 and was observed welding in the 1G (Vertical) position; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-3213-B-U3b.

Segment # 7EW

This QA inspector observed ZPMC qualified welding personnel identified as 037840 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW7N-016 and was observed welding in the 4G (overhead) position; ZPMC QC is identified as Mr. Zhu Yuan. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
